

Work Order ID 117786

May-02-14 8:41:54 AM

117786

Page 1

Item ID: D3580-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Joggle Bracket

Start Date: 5/02/14 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/02/14 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan:  Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3580	Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3580

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

304.080

3 0 JM14-05-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

3 0 JM14-05-2

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(3) 14-05-02 DAS 9 9-09

Work Order ID 117786

May-02-14 8:41:54 AM

117786

Page 2

Item ID: D3580-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Joggle Bracket

Stop

NS2

Start Date: 5/02/14

Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/02/14

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

Bend as per dwg D3580 using 1/8" offset die

0.00

0.00

140

140

QC

Quality Control

QC5- Inspect part completeness to step on w/O

Memo

0.00

0.00

150

150

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Handwritten notes:

W/A - Start for Jessy Harvey

Under Harvey in 44-65-02

405452

Work Order ID 117786

117786

Page 3

May-02-14 8:41:54 AM

Item ID: D3580-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Joggle Bracket

Start Date: 5/02/14 Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 5/02/14 Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 14-05-02

11 140502

Picklist Print

May-02-14 8:41:53 AM

Page 1

Work Order ID: 117786

117786

Parent Item: D3580-1

D3580-1

Parent Item Name: Joggle Bracket

Start Date: 5/02/14

Required Date: 5/02/14

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev :A New Issue 07.06.25 EC

IPP Rev:B Removed Powder Coat 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

578.7100

0.01

1

M304S18GA

JM14-05-2

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT019

566.71

117188

3

117766

5

120604

5

122325

3

123155

3

124572

38

M126647

39.75

M128254

107.71

M128435

187.25

M128864

175

128864.

MAT020

12

124029

2

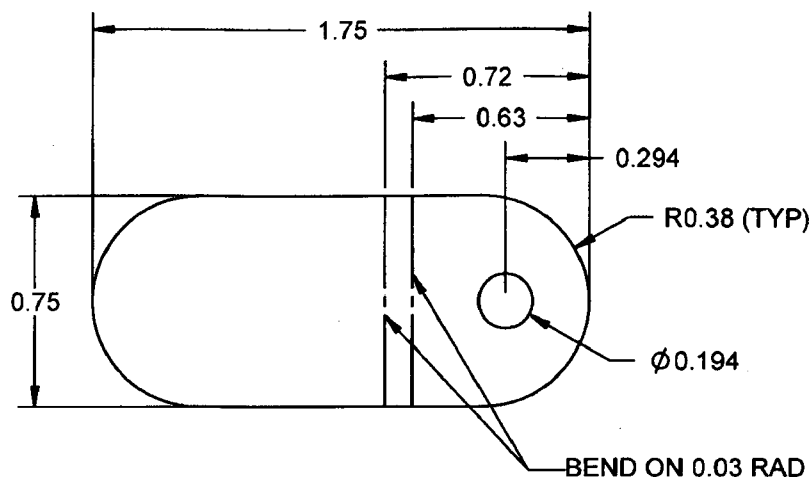
M126098

10

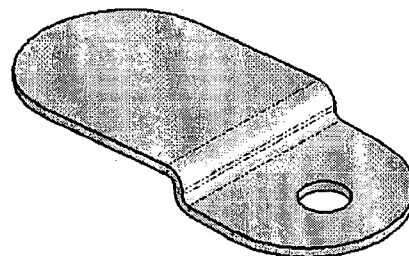
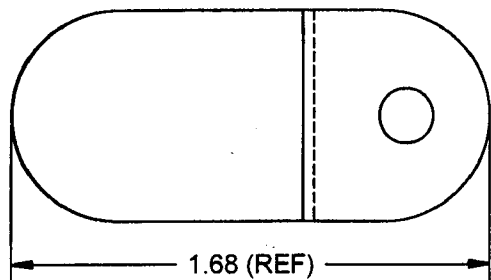
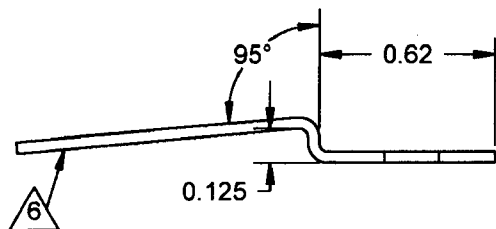


DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3580	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE JOGGLE BRACKET	SCALE 3:2
REV	DATE	DESCRIPTION	
A	07.05.15	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED
07.07.09 *[Signature]*



D3580-1F FLAT PATTERN



w/ 117786

D3580-1 JOGGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

